

Date: Tuesday, 05/05/2009 3:38:00 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEDGE KIT
Job Number : 47754	
Estimate Number : 13915	
P.O. Number :	Part Number : D350636105
This Issue : 05/05/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PREL
Previous Run :	Material :
Written By :	Due Date : 07/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUL 09.05.05</u>	
Comment : Est Rev:A New Issue 09.05.01 EC Verified By:DD	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JD 09/06/08



Comment: DOCUMENT CONTROL *636*
 Photocopy bluefile & type labels per PPP D350-~~363~~ 105

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D39261	Clip
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Clip
 batch: 48307

cnf 09-06-08

4.0	MS21042L3	Nut
-----	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Nut
 batch: M110844

used on Rework 20 #47768 9/6/08

5.0	MS24693S276	SCREW
-----	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 SCREW
 batch: M104394

used on Rework 20 #47758 9/6/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 3:38:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEDGE KIT

Job Number: 47754

Part Number: D350636105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

NAS149D0363J

Washer



AN9600D10.

used on Hewlett



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Washer
batch: *11279- #47754 09/06/08*

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



**ENGINEERING
APPROVAL**



Comment: INSPECT 100% KITS FOR COMPLETENESS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP ~~BS19374-011 CHG 001~~

Location: *Draft*

PPP Rev: *09/06/08*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Sent to Era under positive



09/09/02

Comment: FINAL INSPECTION/W/O RELEASE *Recall w/ C of C 09/06/08*

Job Completion



POSITIVE RECALL

EFFECTIVE *09/05/04* AUTH *LI*

RELEASED *MP* DATE *09/09/02*

MF 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105 Wedge Kit can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105 Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA but is not compatible with OEM skidtubes.

The D350-636-105 Wedge kit is installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Re-install the D2741 blade unto the D350-636 skidtube assembly in accordance with IIN-D350-636.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105 Elf Shoe Kit	0.06 lb 0.03 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	10.70 in-lb 0.14 m-kg

PARTS LIST

QTY. -105	PART NUMBER	DESCRIPTION
X	D350-636-105	Wedge Kit
2	D3926-1	WEDGE
4	MS21042L3	NUT
4	MS24693S276	SCREW
4	NAS1149D0363J	WASHER

PRELIMINARY ISSUE
MP 09/05/01

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A	NEW ISSUE	BY	09.03.31
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DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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MFG. APPR.	N/A	DSI 9456	SHEET 1 OF 2
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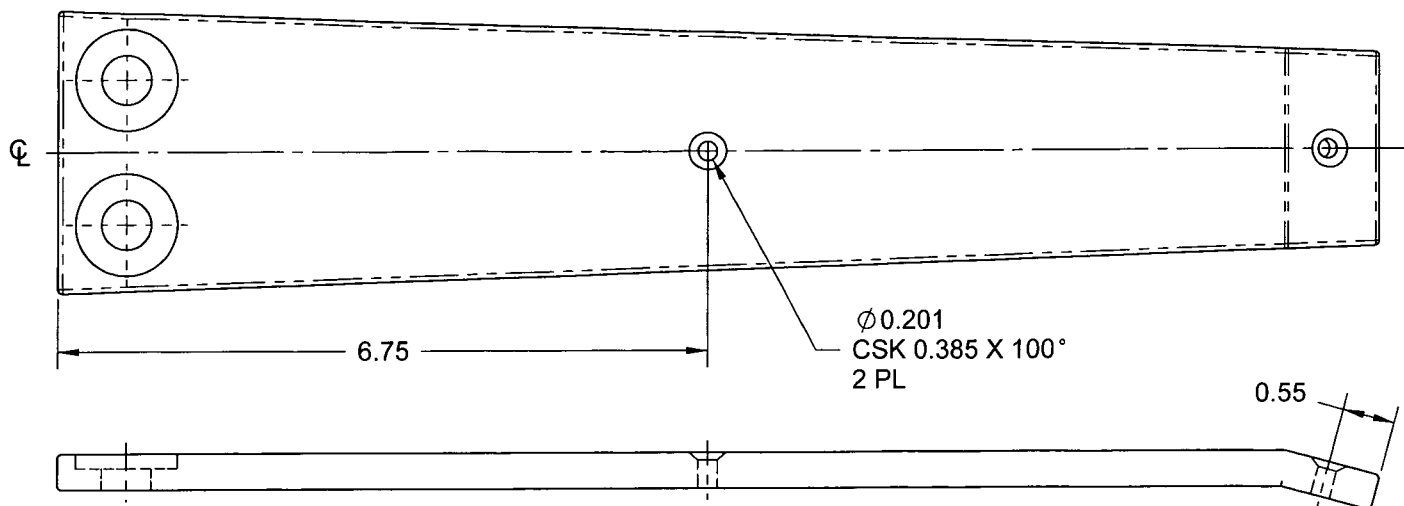


FIGURE 1: D2741 BLADE DRILLING DETAIL

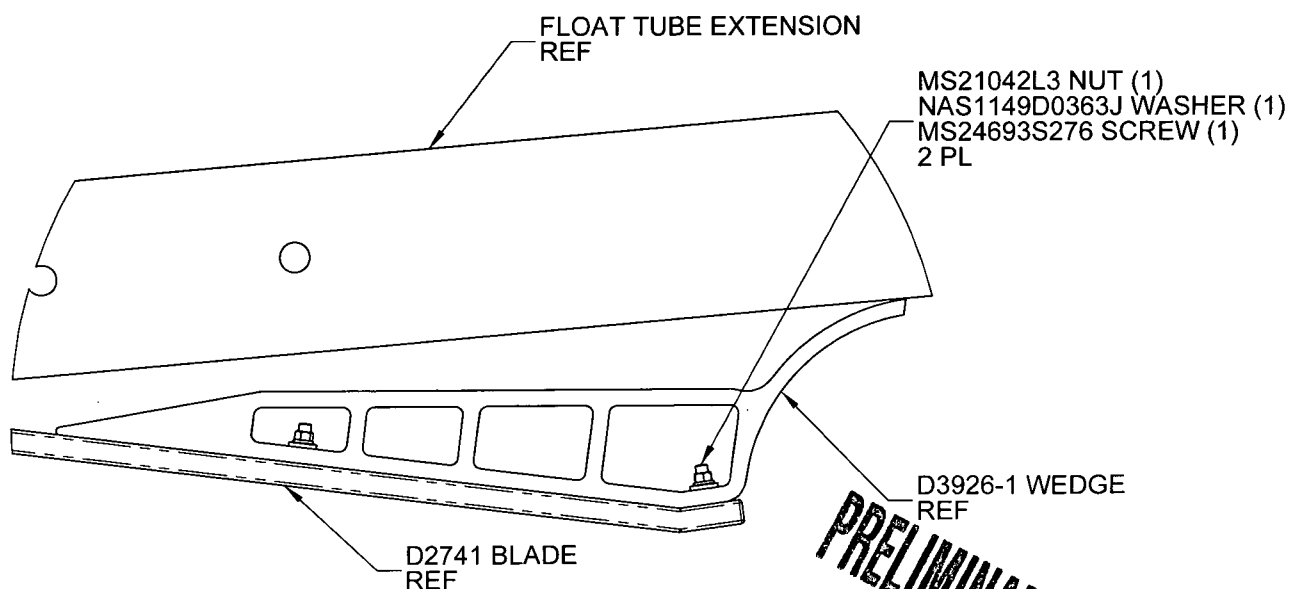


FIGURE 2: D3926-1 WEDGE INSTALLATION

PRELIMINARY ISSUE

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skid tubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skid tubes but is not compatible with OEM skid tubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

47754

A	NEW ISSUE	09.07.23
REV.	DESCRIPTION	BY DATE
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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **DSI 9456** REV. A
SHEET 1 OF 3

TITLE **WEDGE KIT** SCALE NTS

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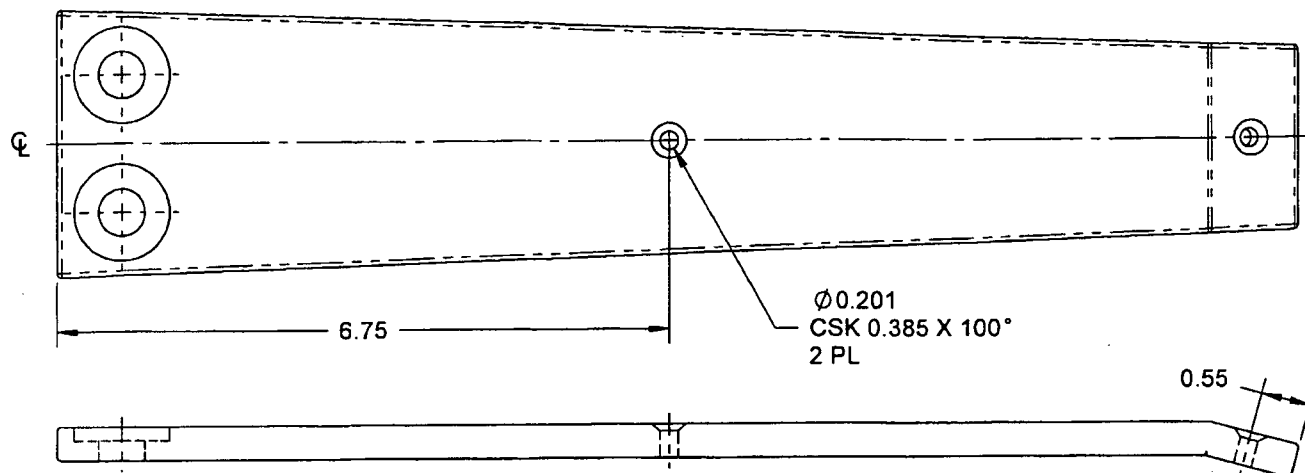


FIGURE 1: D2741 BLADE DRILLING DETAIL

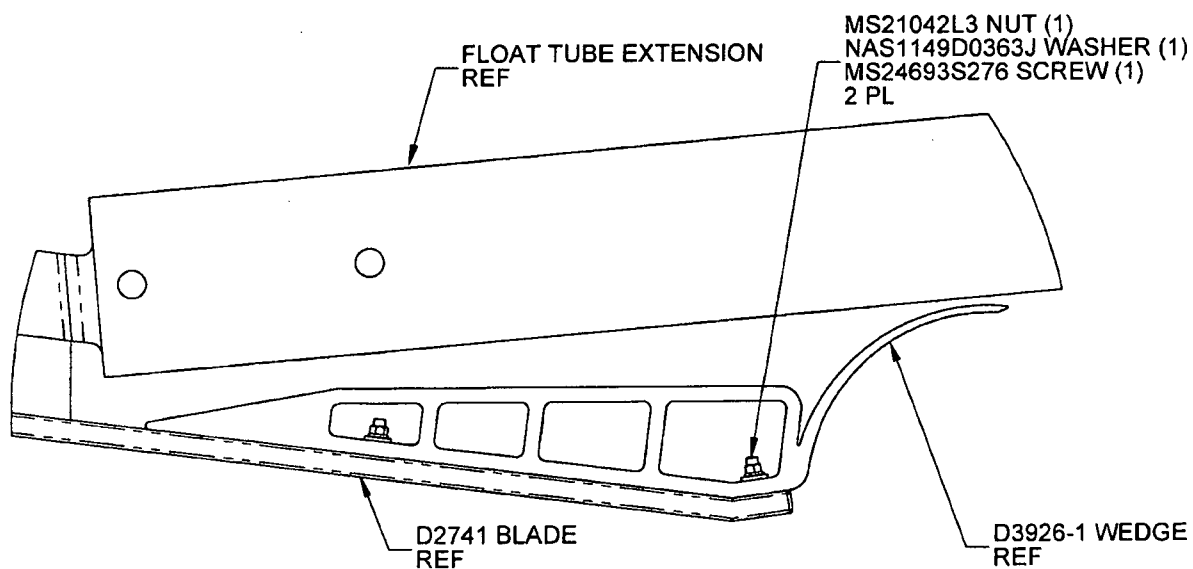


FIGURE 2: D3926-1 WEDGE INSTALLATION

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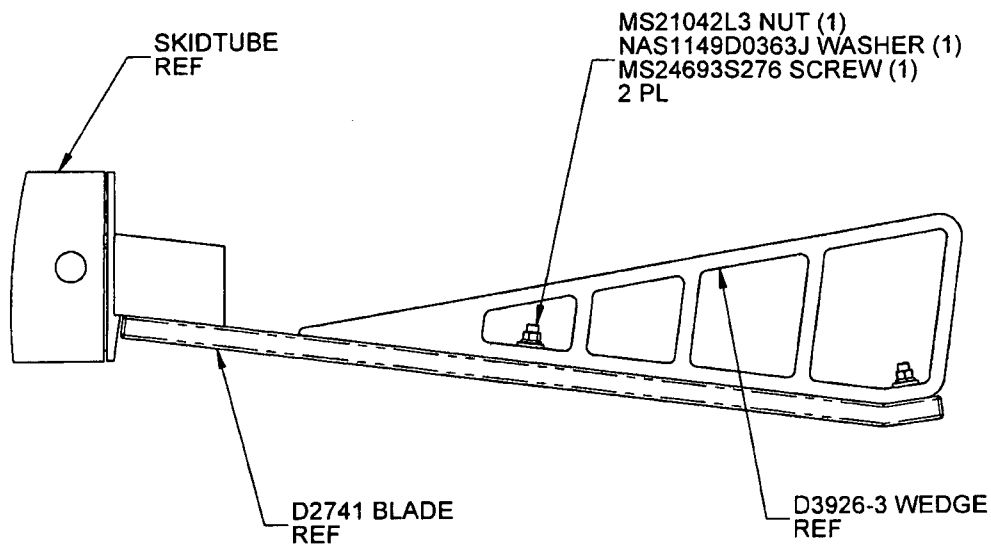


FIGURE 3: D3926-3 WEDGE INSTALLATION

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